

Work Order ID 129598

129598

Page 2

February-18-15 1:23:48 PM

Item ID: D5222-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 2/18/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00				8	15-2-25	DAS 38 9-89	DAS 50 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>Ship</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 150219 AUTH 11

RELEASED 11 DATE 150224

per ECN 15-529

Picklist Print

February-18-15 1:23:48 PM

Page 1

Work Order ID: 129598

129598

Parent Item: D5222-041

D5222-041

Parent Item Name: Wearplate Assembly

Start Date: 2/18/15

Required Date: 3/06/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

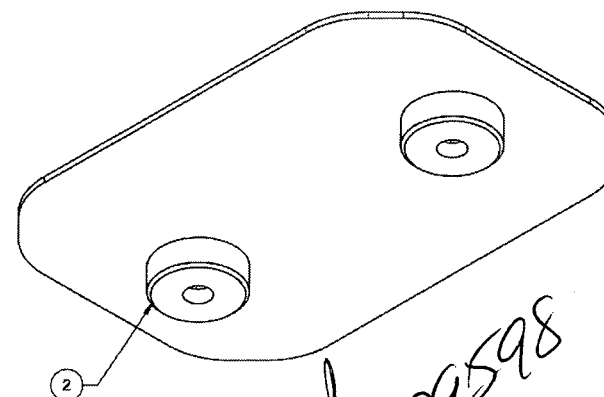
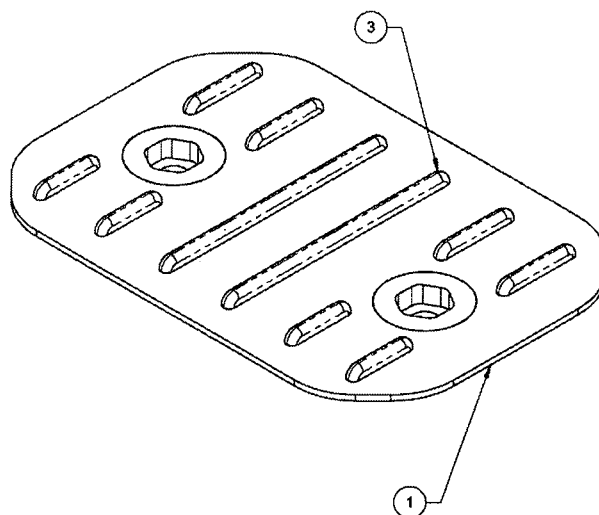
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-5		Manufactured	No				Each	52.0000		32			
D4379-5									**				
Wearplate Cup													
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					ST103			52					
					126889			52					
D5222-1		Manufactured	No				Each	0.0000		8			
D5222-1									**				
Wearplate													

129598x8

A 15-2-23

A 15-2-23

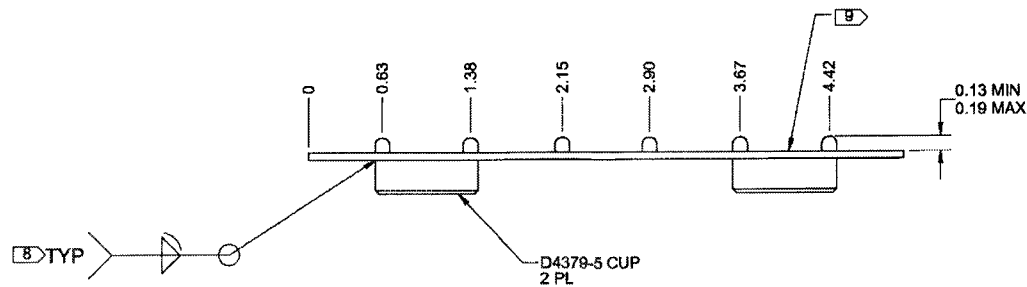
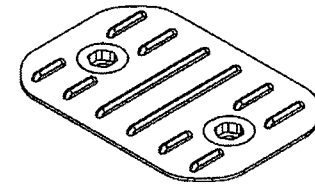
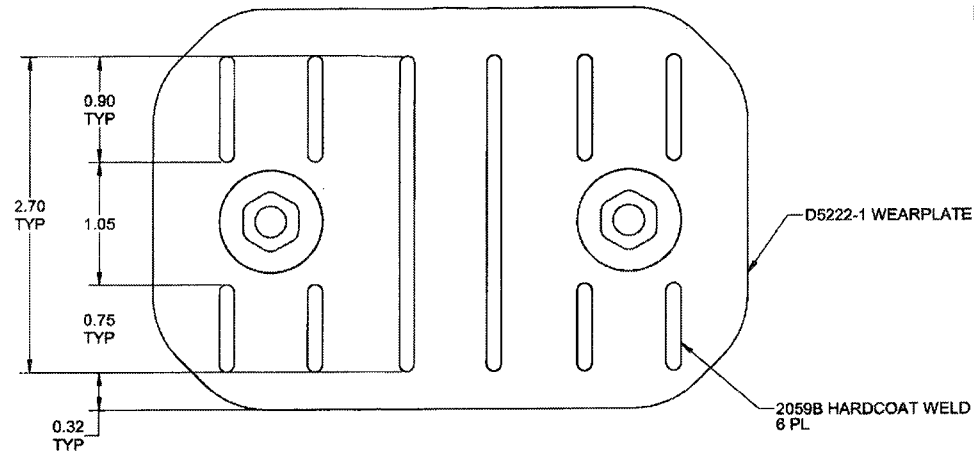
ITEM	QTY	P/N	DESCRIPTION
X	X	D5222-041	WEARPLATE ASSEMBLY
1	1	D5222-1	R22 WEARPLATE
2	2	D4379-5	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D5222-041 WEARPLATE ASSEMBLY

A		NEW ISSUE		VS	15.02.04
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 3	
DRAWN	VS				
CHECKED	RF	DRAWING NO. D5222		SCALE	
MFG. APPR.	DD	TITLE WEARPLATE		NTS	
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DE APPR.	DS				
DATE		15.02.04			

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NOTES:

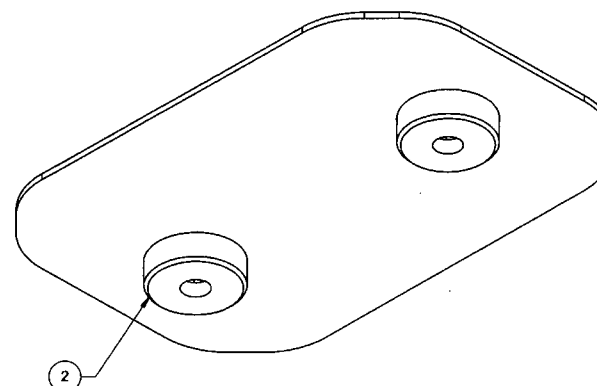
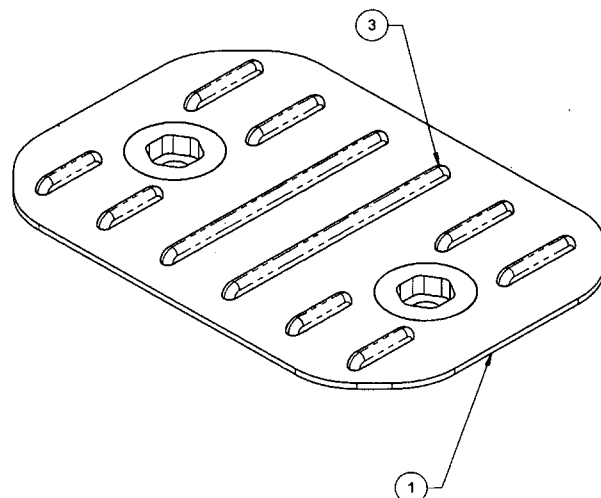
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) WELDING PER QSI 004
- 9) D4379-5 FLUSH WITH SURFACE

D5222-041 WEARPLATE WELDING DETAIL

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5222	SHEET 2 OF 3
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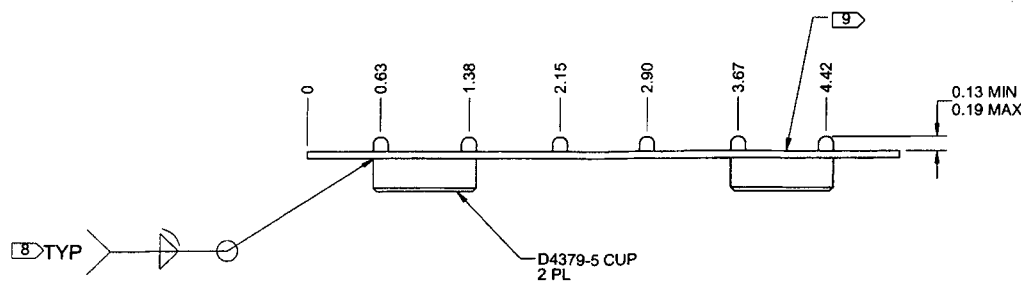
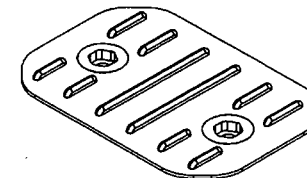
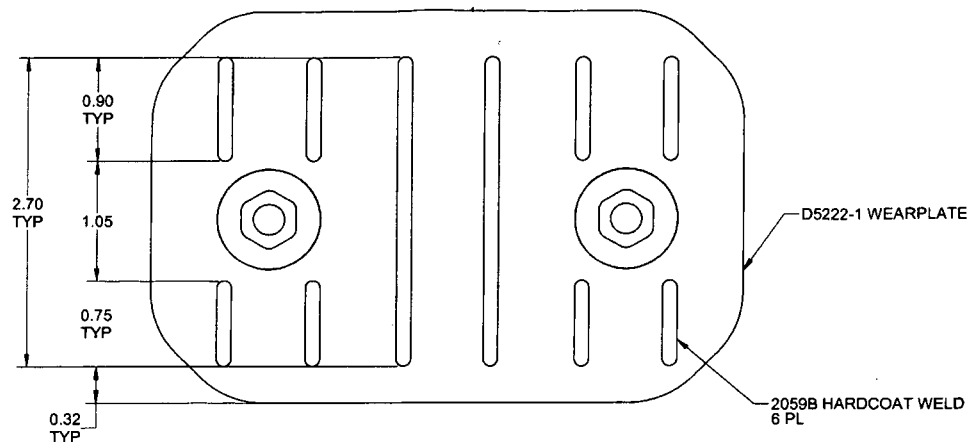
D5222-041 WEARPLATE ASSEMBLY

RELEASED

2015 FEB 23
ECP 15-524

A		NEW ISSUE		VS	15.02.04
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	VS			SHEET 1 OF 3	
CHECKED	RF	DRAWING NO. D5222		SCALE	
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DE APPR.	DS				
DATE 15.02.04					

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2015 FEB 23 *qp*

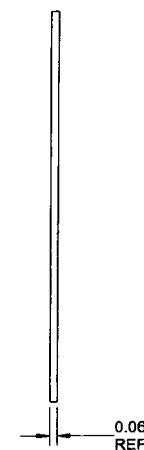
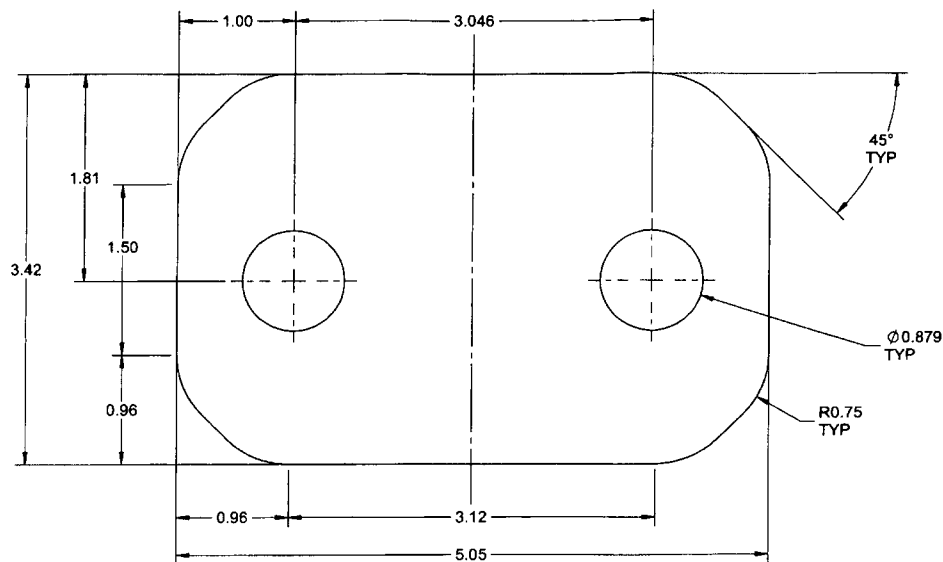
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 8) WELDING PER QSI 004
- 9) D4379-5 FLUSH WITH SURFACE

**D5222-041 WEARPLATE
WELDING DETAIL**

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D5222	REV. A SHEET 2 OF 3
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DATE	15.02.04		



D5222-1 R22 WEARPLATE

RELEASED

2015 FEB 23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
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